

Date: Wednesday, 05/11/2008 3:24:29 PM
 User: Julie Dawson

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG
 Job Number : 43223 -1
 Estimate Number : 10256
 P.O. Number :
 This Issue : 05/11/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D22303
 First Issue : 11 Type : MACHINED PARTS Drawing Number : D2230 REV F
 Previous Run : 42316 Drawing Revision : F
 Material :
 Due Date : 20/11/2008 Qty: 200 Um: Each
 Written By :
 Checked & Approved By : JUD 08.11.05
 Comment : Est D 00.05.18 Added inspection level B, and removed P/O for powder coat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)

Lug Extrusion

D2423

Batch: 43722

2.0 BAND SAW BAND SAW



cut @ meter

Comment: Band Saw

Cut D2423 extrusion to 0.82"

Batch:

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



issue P/O: 7556 meter

Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

colob 111111

(200)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



rec'd + inspect attached cal/c

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

P-8/14/31 (74)

5.0 QA SECOND CHECK



Comment: SECOND CHECK

Sorbalos (74) counter

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 43223

Part Number: D22303

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble and deburr rough edges after tumbling

Handwritten: n/a 5/9/15

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

Handwritten: AWM

Handwritten: 7-01-06 A 74/PCS

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 5/8/01/06 (74)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME: *7:30*
OVEN TEMPERATURE: *320°*
FINISH TIME: *8:00*

Handwritten: m109996

Handwritten: FL 08/01/07 (74)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT INSPECT POWDER COAT

Handwritten: 09-01-07 (74)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *51476*

Handwritten: 88 01/01/07 (74)

12.0

QC21

FINAL INSPECTION/W/O RELEASE

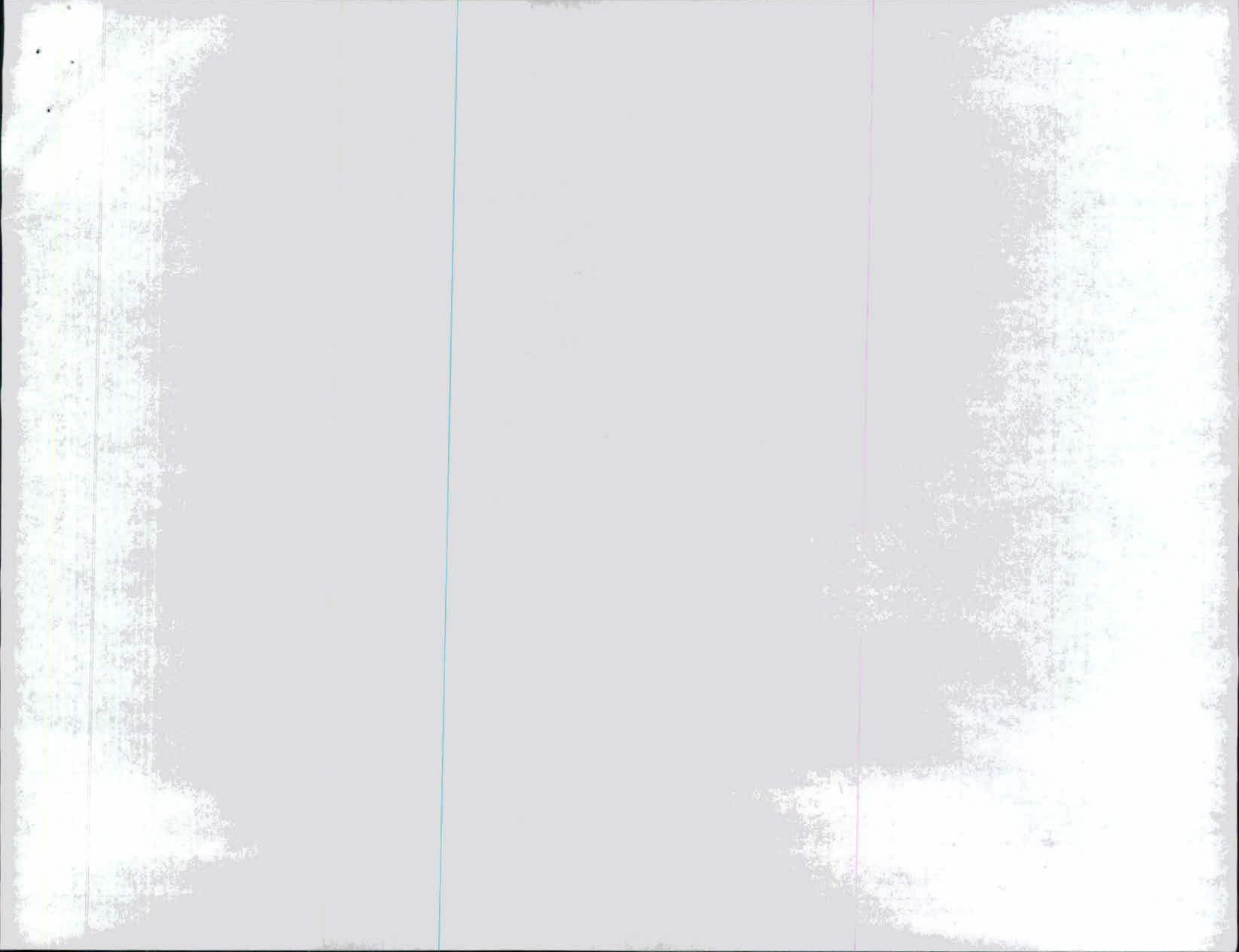


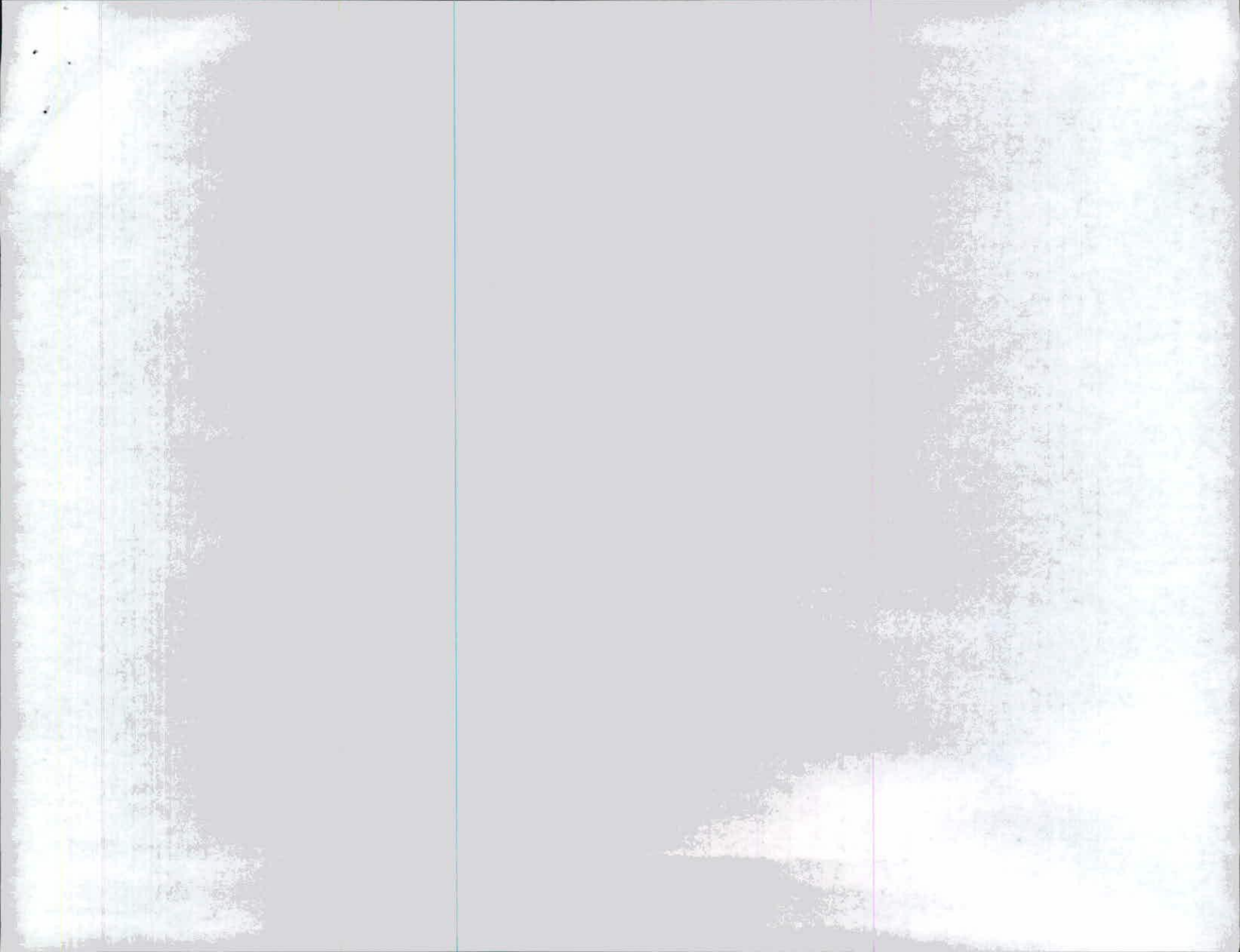
Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 09/01/07 MF 09-01-07 (74)

Job Completion

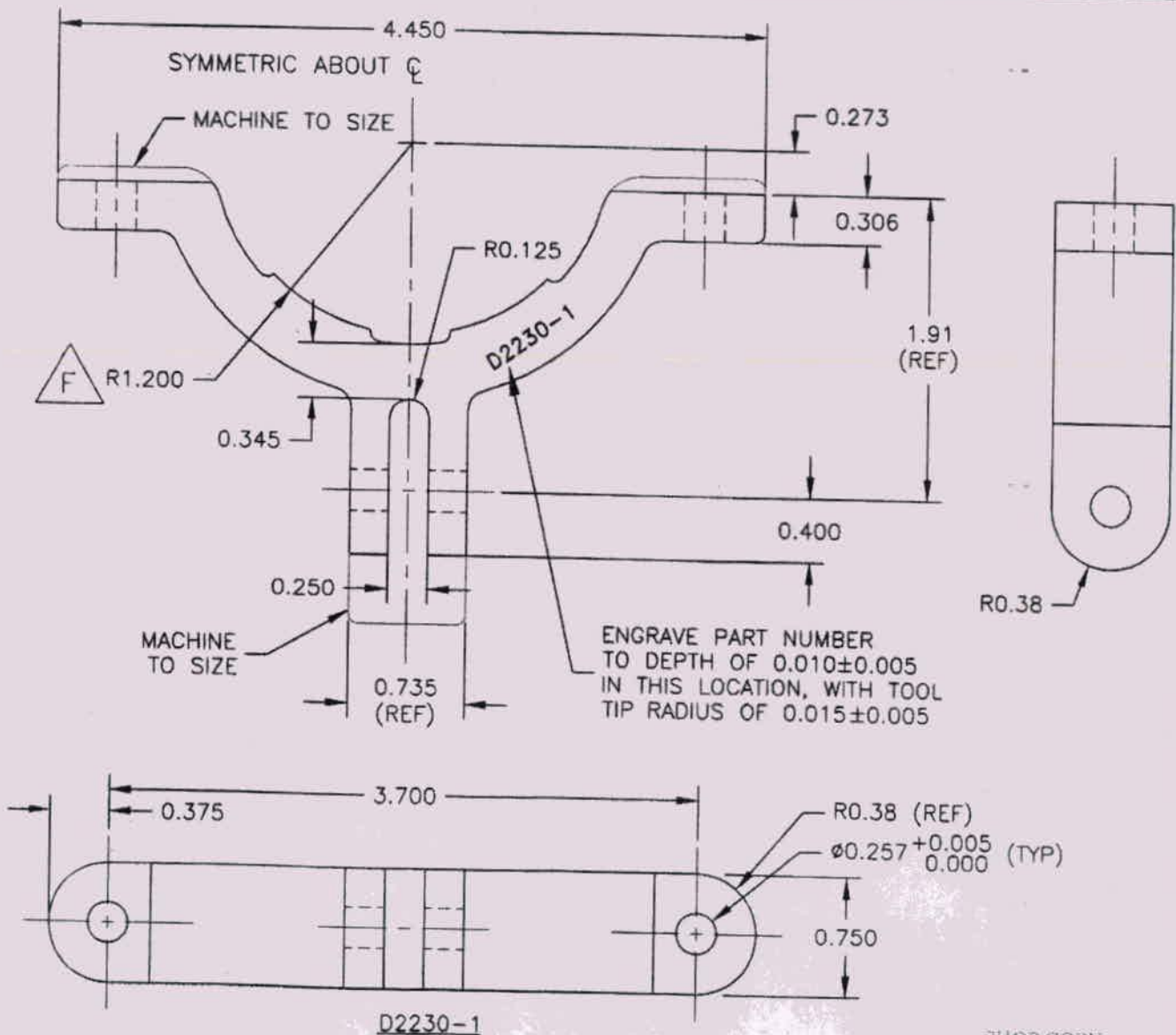






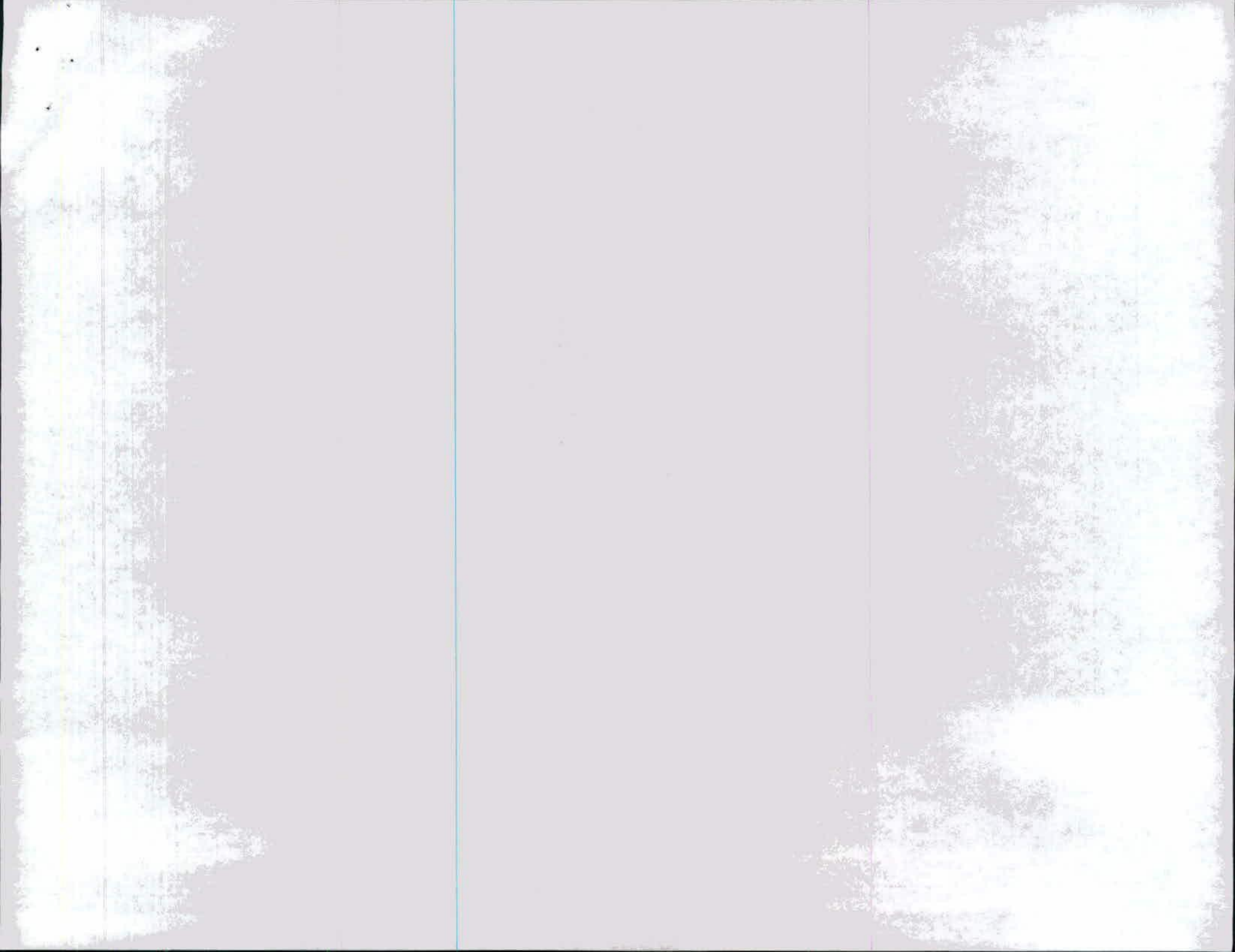
DART**RELEASED**
19.12.21 DS

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. F
				D2230	SHEET 1 OF 2
DATE	99.12.13			TITLE	SCALE
				MOUNTING LUG	1:1
C		94.03.30		RE-DESIGN	
D		95.01.04		RE-DESIGN	
E		95.01.04		RE-DESIGN	
F		99.12.13		REDESIGN; R1.200 WAS R1.100	



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

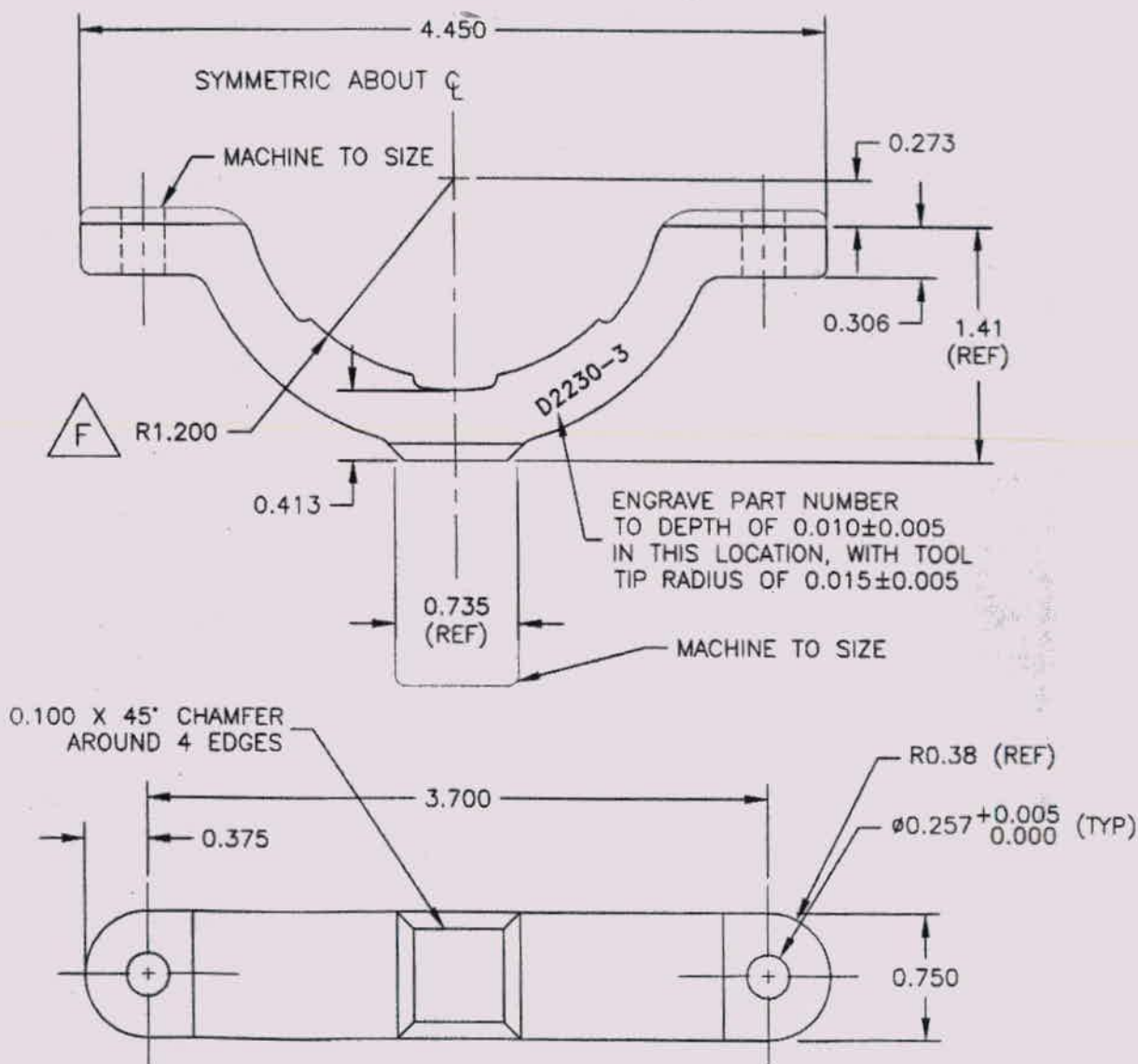
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
43223





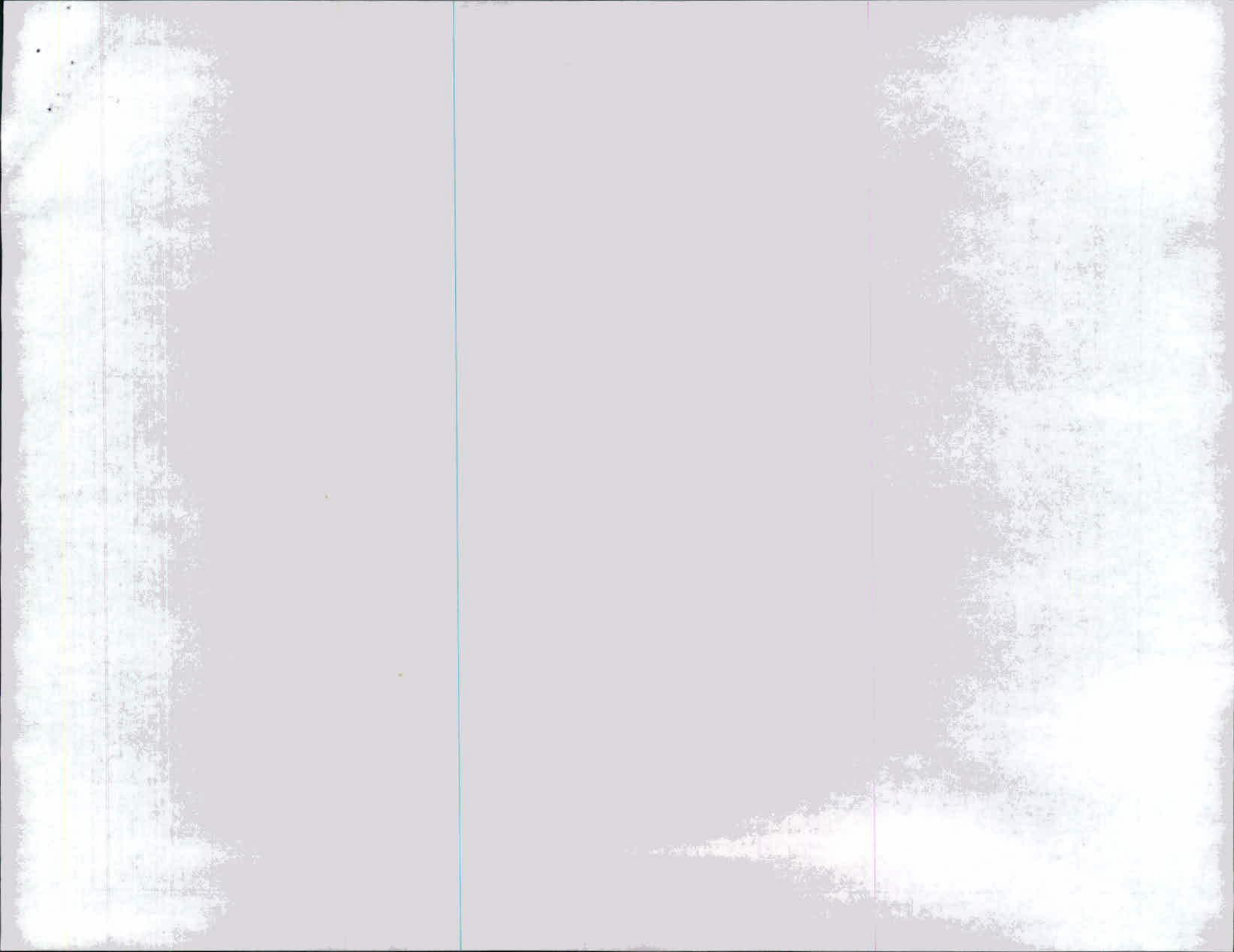
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
79.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43223





CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

74

D2230-3

Mounting lug

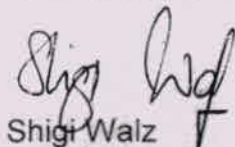
7556

MATERIAL: supplied by DART D2423 B43722

802/01/05

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, December 24, 2008

